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D350-616-011 Job Sheet 189390



Part No: D350-616-011

Job Qty: 1 pcs

Part Name: Full Emergency Litter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/23/19

Job Tracking No:

Due Date: 2/12/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV H IPP E 03.04.04 Reformat KJ/RF IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec IPP
REV:G 13.05.21 AS PER DWG REV.G DD VERF:JLM IPP REV:H 16.04.19 NOW @ CHG007 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs			
101	Small Fab - 1	1 pcs	2/12/19		0.00	0.65	Small Fab - 1		DAS 58 9-89 FEB 06 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
105	QC 5	1 pcs	2/12/19		0.00	0.00	QC 5 - 10		DAS 68 9-89 FEB 06 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
119	Packaging 1-1 - Pick Kit - B4B	1 pcs	2/12/19		0.00	0.00	Packaging 1 - 1 - B4B		DAS 46 9-89 FEB 07 2019
							Packaging 1 - 2 - B4B		
							Packaging 1 - 3 - B4B		
							Packaging 1 - 4 - B4B		

				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
120 QC 4	1 pcs	2/12/19	0.00 0.00	QC 4 - 26	
				QC 4 - 28	
				QC 4 - 38	
				QC 4 - 42	
				QC 4 - 58	
				QC 4 - 6	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
130 Packaging 3-1 - Stock - B4B	1 pcs	2/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	

DAS
46 FEB 07 2019
9-89

					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DA5
135	DC - 1 - B4B	1 pcs	2/12/19	0.00 0.00	DC - 1 - B4B	21 FEB 07 2019
					DC - 2 - B4B	3-08
140	QC 21 - FG	1 pcs	2/12/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	DA5 FEB 07 2019
Part Op 101 - (Small Fab) 1- Assemble as per Dwg D2370 2- Transfer drill using D4812-041 as template and open to size 0.250"						
Descriptions: as per Dwg D2370 AND DT9935 DRILL JIG 3- Ensure fit of D4812-041 and remove for shipping ***D4812-041 MUST STAY WITH LITTER FRAME*** 4- Deburr						
105 - (QC5- Inspect part completeness to step on W/O)						
119 - (Pick Kit)						
120 - (QC4- 100% Inspect kits for completeness)						
130 - Identify and pack for shipping as per PPP D350-616-011 Location: _____ PPP Rev: _____						
135 - (Document Control) Photocopy bluefile and create labels per PPP D350-616-011 CHG007						
140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D2370-1	Litter Frame Assembly	1 Ea (1 ea)	101-Small Fab - 1	S151144		
D4812-041	Patient Stop Assembly	1 pcs (1 ea)	101-Small Fab - 1	S151500		
D350-616-013	Deck Plate & Tie Down	1 pcs (1 ea)	119-Packaging 1-1 - Pick Kit - B4B	S151603		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
101-Small Fab - 1	D2370-1	1	1	0		
	D4812-041	1	0	0		
119-Packaging 1-1 - Pick Kit - B4B	D350-616-013	1	2	0		
Part Specifications						
Specifications could not be found.						

ITEM	QTY -041	P/N	DESCRIPTION
	X	D2370-041	LITTER ASSEMBLY
1	1	D2370-1	LITTER FRAME ASSY
2	1	D4812-041	PATIENT STOP ASSY

D2370-1 LITTER FRAME ASSEMBLY

D4812-041 PATIENT STOP ASSY

POSITION PATIENT STOP OVER
FWD STUDS AND SECURE
WITH PIP PINS

D2370-041 LITTER ASSEMBLY

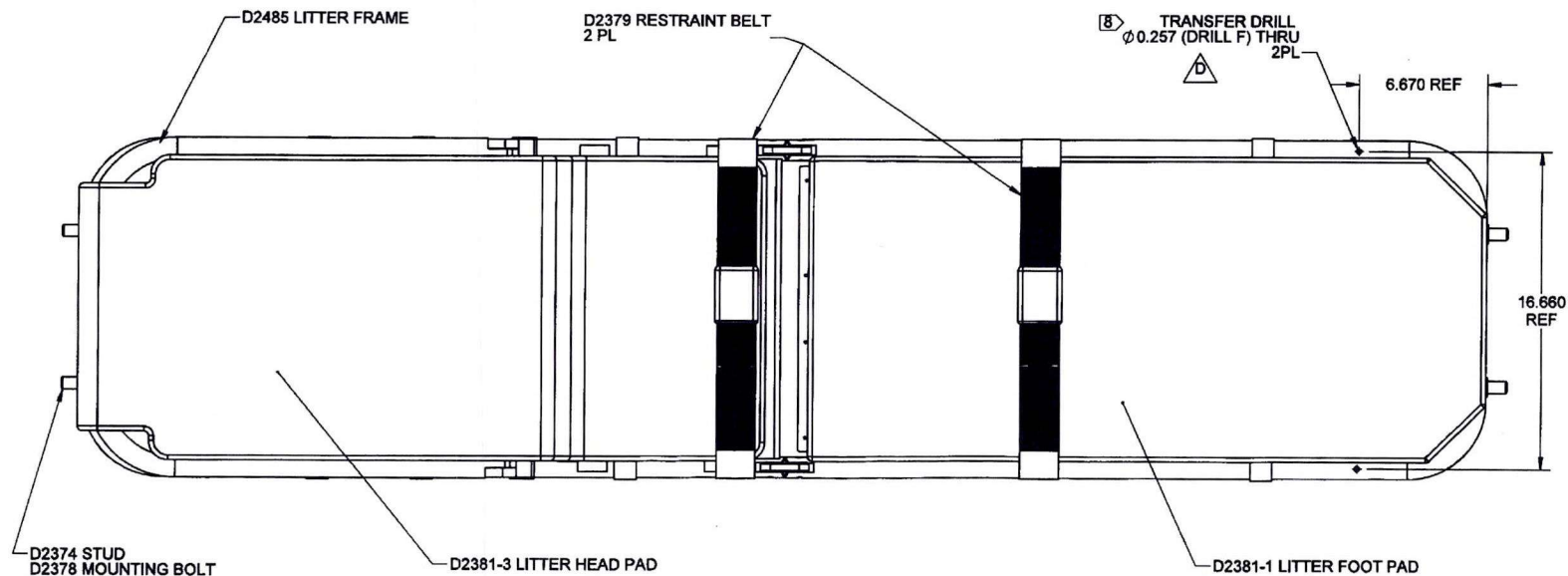
RELEASED
2013-05-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 25.73 Lbs

D	Ø0.257 HOLES WERE Ø0.191 HOLES, 2PL (ZN C3-2), CREATED -1 AND -041 ASSEMBLIES, NEW DWG FORMAT	DB	13.03.27
C	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES AND 5.00 WAS 5.34	KE	06.11.21
B	ADDED Ø0.191 HOLES	KE	98.06.09
A	NEW ISSUE	NA	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	2/1	D2370	SHEET 1 OF 2
APPROVED	1/1	TITLE	SCALE
DE APPR.	1/1	LITTER ASSEMBLY	NTS
DATE	13.03.27	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -1	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN960JD416L	WASHER



D2370-1 LITTER ASSEMBLY

RELEASED
2013-05-16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QS1 044 METHOD 6.6
 - 7) WEIGHT: 24.69 Lbs
 - 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

DESIGN DRAWN	DB DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO. D2370	REV. D
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE LITTER ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.03.27		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			



Container No: S151294

Part: D350-616-011

Job No: 189390

Serial No/Batch: S151294

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96-10 Issue 3 Ref AASITC SR004051

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